Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKID TUBE ASSEMBLY
Job Number	: 40380		
Estimate Number	: 10023		
P.O. Number	:	**Part Number**	: D205634041
This Issue	: 08/07/2008 **S.O. No.** :	**Drawing Number**	: D2580 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SKIDTUBES	**Drawing Revision**	: D
Previous Run	: 40379	**Material**	:
Written By	:	**Due Date**	: 30/07/2008 **Qty:** 1 **Um:** Each
Checked & Approved By	: JLD 08.7.08		

Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

JLD 08.7.18

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002 δ 08/07/09

Seq. #:	Machine Or Operation:	Description :
2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	D37544 ① M 8-7-9

Seq. #:	Machine Or Operation:	Description :
3.0	D2596	Web, 205 Skidtube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: AWM *

Qty	Part Number	Description	Batch
1	D2596	205 Web	B-40322 8-7-14

Seq. #:	Machine Or Operation:	Description :
4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

M 8-7-9

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 40380
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   a m 08.07.14

Seq. #:	Machine Or Operation:	Description :
6.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291		M107888

Sikaflex expire date: 8-11-01
Start Time: 9:05 Date: 8-11-01
Fin Time: 7:30 Date: 8-11-14

AWM 8-7-14

Seq. #:	Machine Or Operation:	Description :
7.0	BENDING	BENDING MACHINE - SKIDTUBES

Comment: BENDING MACHINE
1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580   AT 08-7-15

Seq. #:	Machine Or Operation:	Description :
8.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.   M 8-7-15

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 40380
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BE 08/07/15

Seq. #:	Machine Or Operation:	Description :
10.0	D25763	Step (maching detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B38392

BF 08/07/15

Seq. #:	Machine Or Operation:	Description :
11.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B39561

(20) M 8-7-15

Seq. #:	Machine Or Operation:	Description :
12.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod m108096 BE 08-07-15

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod m108096 BE 08-07-15

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

AWM 8-7-16

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 40380
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	QC10	VISUAL INSPECTION OF GROUND WELDS

Comment: VISUAL INSPECTION OF GROUND WELDS — S 08/07/17

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP — S 08/07/17

Seq. #:	Machine Or Operation:	Description :
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005 — 08/07/21

Seq. #:	Machine Or Operation:	Description :
16.0	POWDER COATING	POWDER COATING

M108523

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30
08/07/21

Seq. #:	Machine Or Operation:	Description :
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION — 08-07-22

Seq. #:	Machine Or Operation:	Description :
18.0	D2855	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B39562

Seq. #:	Machine Or Operation:	Description :
19.0	AN35A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M100188

08-07-23

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 40380
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M 104885	BK
21.0	ALS71032160	Insert
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) Insert Batch: M 105819	BK
22.0	AN3C4A	BOLT
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) BOLT Batch: M 108558	BK
23.0	AN960C10L	washer
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) washer Batch: M108077	BK
24.0	D356613	Gasket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B 39574	BK
25.0	D35665	Gasket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B 46401	BK
26.0	D35661	Gasket
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) GASKET Batch: B 46290	BK

BK 08-07-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services   **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 40380   **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	D356413	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B 39791   BK

28.0	D356411	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B 40191   BK

29.0	D35649	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B40583   RD/BK

30.0	D35645	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B 39573   BK

31.0	D25943	O-Ring, 205 Skidtube

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: B29908   BK

32.0	D25941	Plug, 205 Skidtube

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: B 40396   BK

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M107888   RD/BK 08-07-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 2:13:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 40380 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :

Sikaflex expire date: 08-11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M 107888
Sikaflex expire date: 08-11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M 108496

BK 08-07-23

Seq. #:	Machine Or Operation:	Description :
34.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Seq. #:	Machine Or Operation:	Description :
35.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location: 13
PPP Rev: H

Seq. #:	Machine Or Operation:	Description :
36.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

MF 08-07-30

B 40380

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

A		96.09.16	NEW ISSUE
B		96.12.02	AS MANUFACTURED
C		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED 07.06.28

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. 46380

NO. 1162

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 840144A
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[✓] Mig[ ]
Base materiel: Aluminium
Current: AC[✓] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[ ]
Penetration:	pass[✓]	fail[ ]

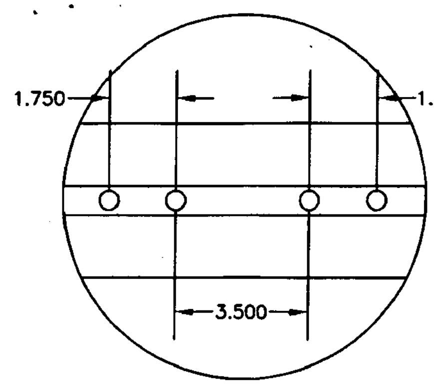
UNACCEPTABLE

Cracks:	pass[✓]	fail[ ]
Undercut:	pass[✓]	fail[ ]
Pin holes:	pass[✓]	fail[ ]
Overlap (cold lap)	pass[✓]	fail[ ]
Porosity (surface):	pass[✓]	fail[ ]
Coloration:	pass[✓]	fail[ ]

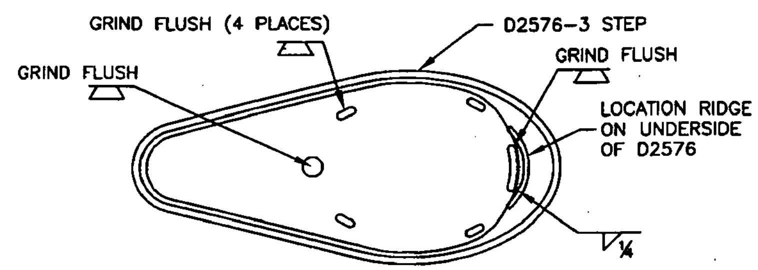
Qualifier Pat. Dunn **Date of Test Coupon** 08-07-11
Welder Barclay Elliott **Date of Test Coupon** 08-07-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

DETAIL A
SCALE 5:24

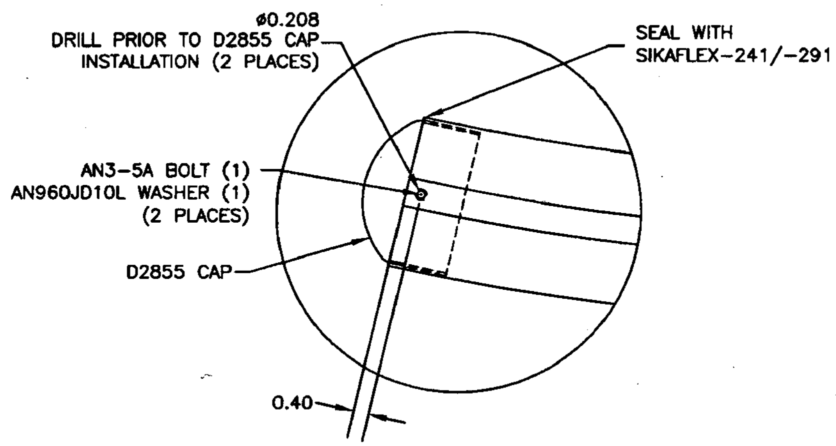


DETAIL B
SCALE 5:24

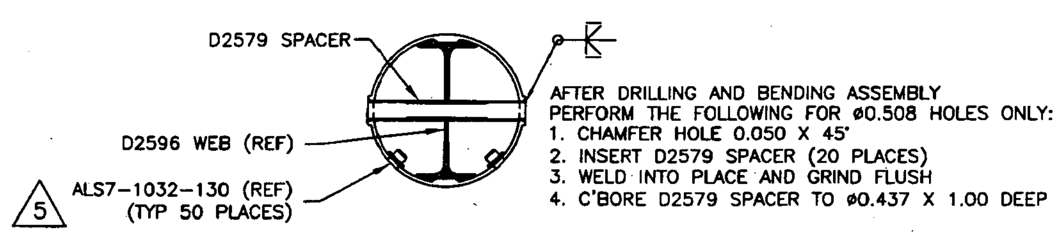


RELEASED 07-02-28

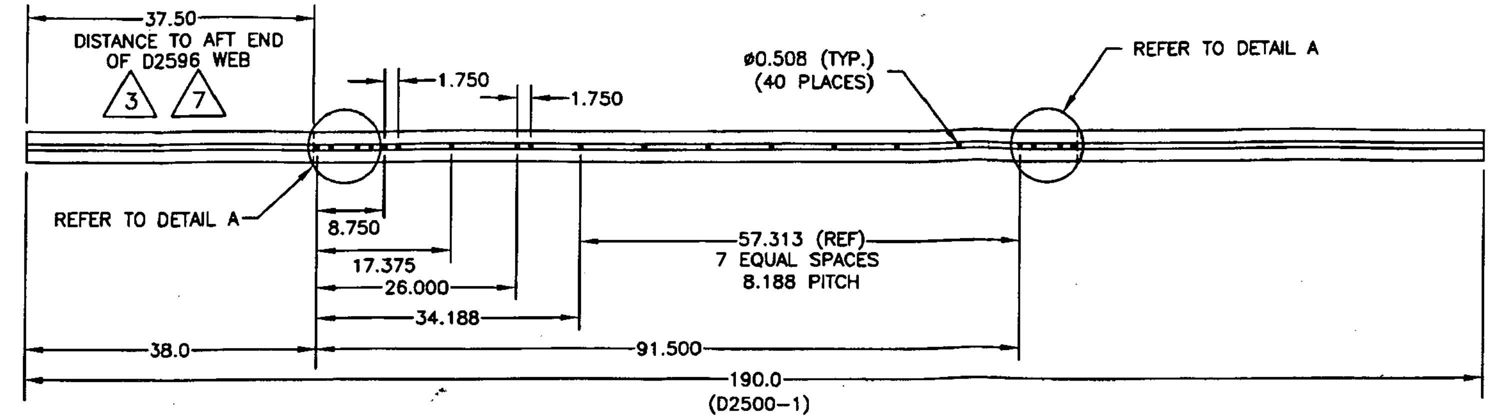
DETAIL C
SCALE 5:24



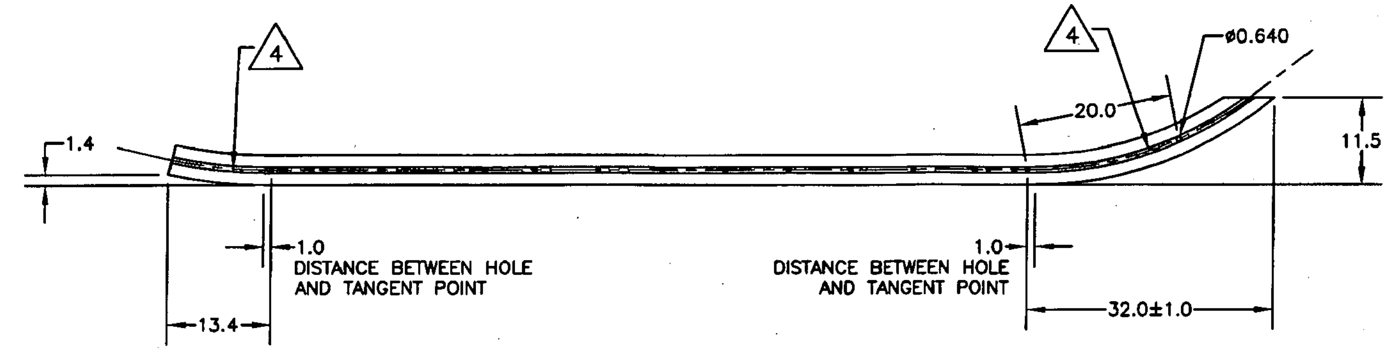
SECTION D–D
SCALE 5:24



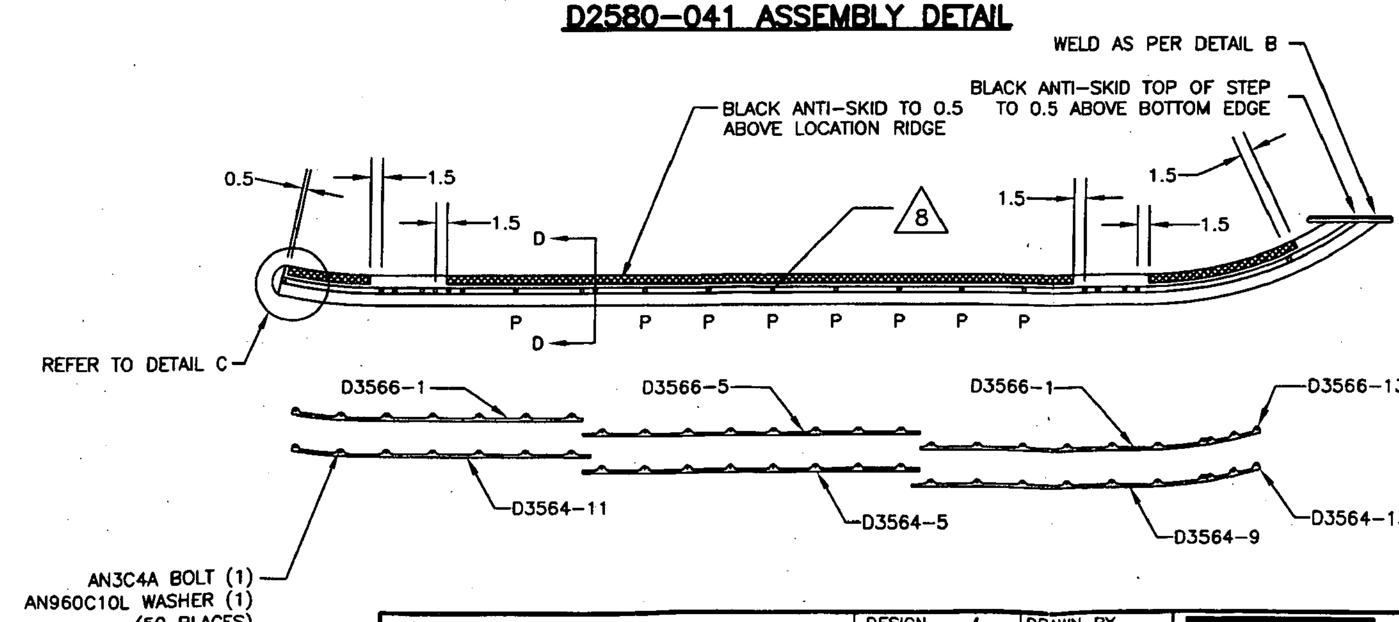
D2580–1 DRILLING DETAIL



D2580–1 BENDING AND CUTTING DETAIL



D2580–041 ASSEMBLY DETAIL

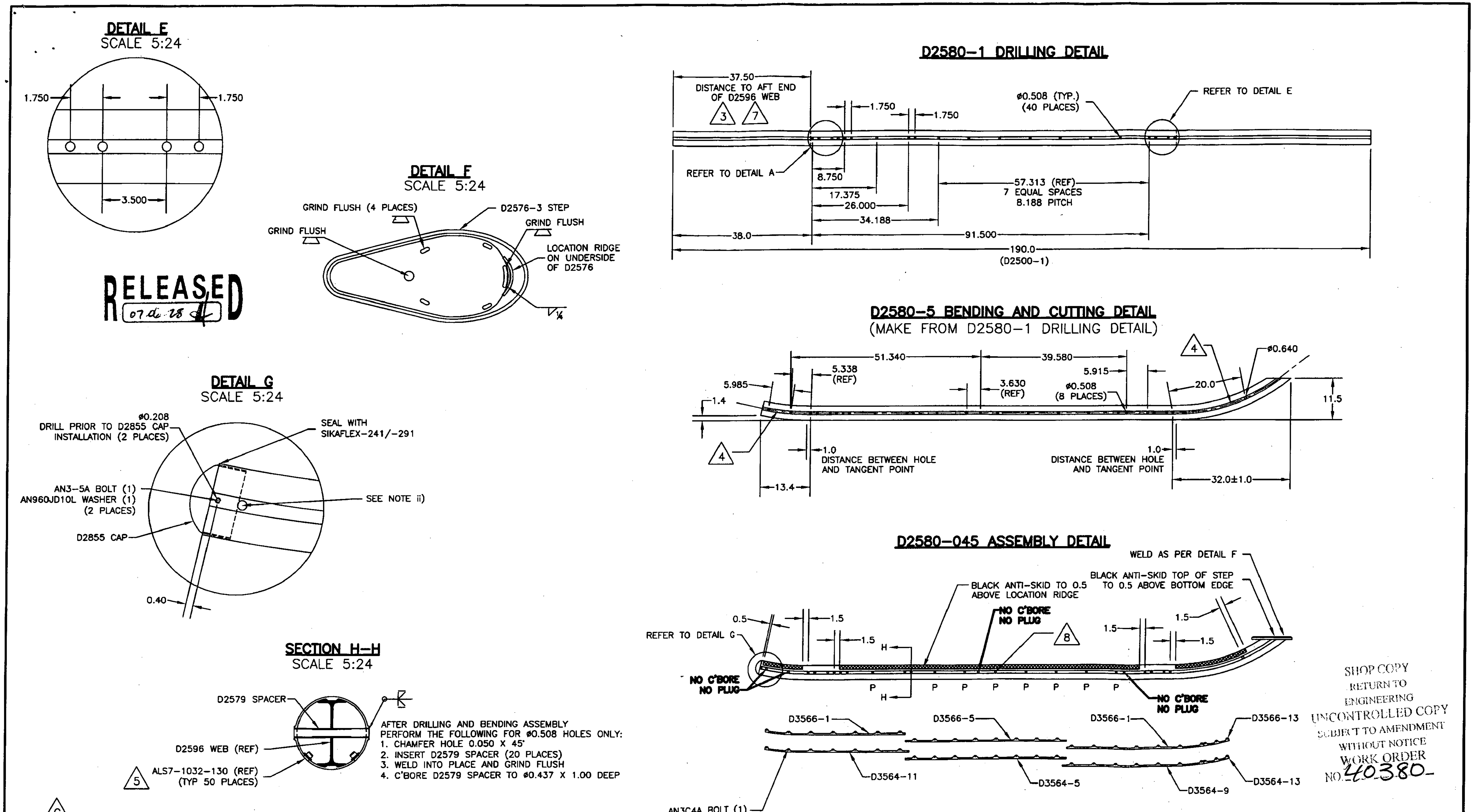


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WITHOUT NOTICE
WORK ORDER
NO. 40380

D2580–041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI–SKID PAINT AS INDICATED PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24



D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
RH	RH	DRAWING NO. D2580 — REV. D — SHEET 3 OF 3
CHECKED	APPROVED	
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24